

Date: Monday, 16/10/2006 7:48:36 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HINGE BRACKET
Job Number	: 28948		
Estimate Number	: 10224		
P.O. Number	: <i>N/A</i>	Part Number	: D2143
This Issue	: 16/10/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D2143 REV. C1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: C1
Previous Run	: 28948	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 19/10/2006 Qty: 40 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est C 00.05.18 Added inspection level 8 EC		
	: Est Rev:D Now on WaterJet 06-10-15 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S040	5052-H32 .040 Sheet
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Comment: Qty.: 0.0693 sf(s)/Unit Total : 2.7720 sf(s)

Material: 5052-H32 (QQ-A-250/8) 0.040" thick
 (M5052H32S.040)

Batch: *M101875**ml 06 10 18*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2143

Dwg Rev: *C1*

Prog Rev: *C1*

*ml 06 10 18**(40)*

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Job 10-18 (40) carried

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

~~Tumble and Deburr~~

*Deburr**ml 06/10/00**(40)*

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Seq. #: Machine Or Operation: Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D2143

SD 04/10/24 (40)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 10.24 (40)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MM

06/10/25

(40)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M101575

yl 06/10/26 x 40

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Pl 6/10/27 (40)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 25

Pl 6/10/27 (40)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SD 06/10/27

Job Completion



C 206/10/27

DART AEROSPACE LTD		Work Order:	28948
Description: Hinge Bracket		Part Number:	D2143
Inspection Dwg: D2143	Rev: C1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.340	+/-0.010	0.340	✓		Vern	
0.625	+/-0.010	0.625	✓		Vern	
1.000	+/-0.010	1.000	✓		Vern	
R0.063	+/-0.010	R0.63	✓		Radius Gauge	
2.656	+/-0.010	2.653	✓		Vern	
3.317	+/-0.010	3.323	✓		Vern	
Ø0.257	+0.005/-0.000	0.257	✓		Vern	
Ø0.171	+0.005/-0.000	0.171	✓		Vern	
1.660	+/-0.010	1.659	✓		Vern	
2.844	+/-0.010	2.846	✓		Vern	
1.659	+/-0.010	1.654	✓		Vern	
R0.125	+/-0.010	R0.125	✓		Radius Gauge	
2.312	+/-0.010	2.315	✓		Vern	

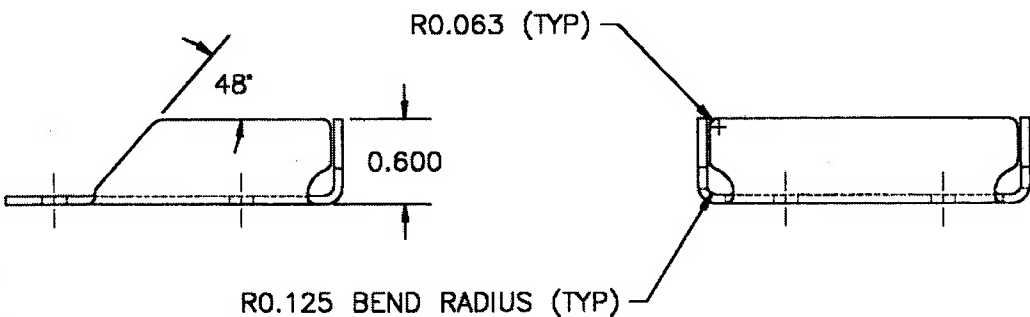
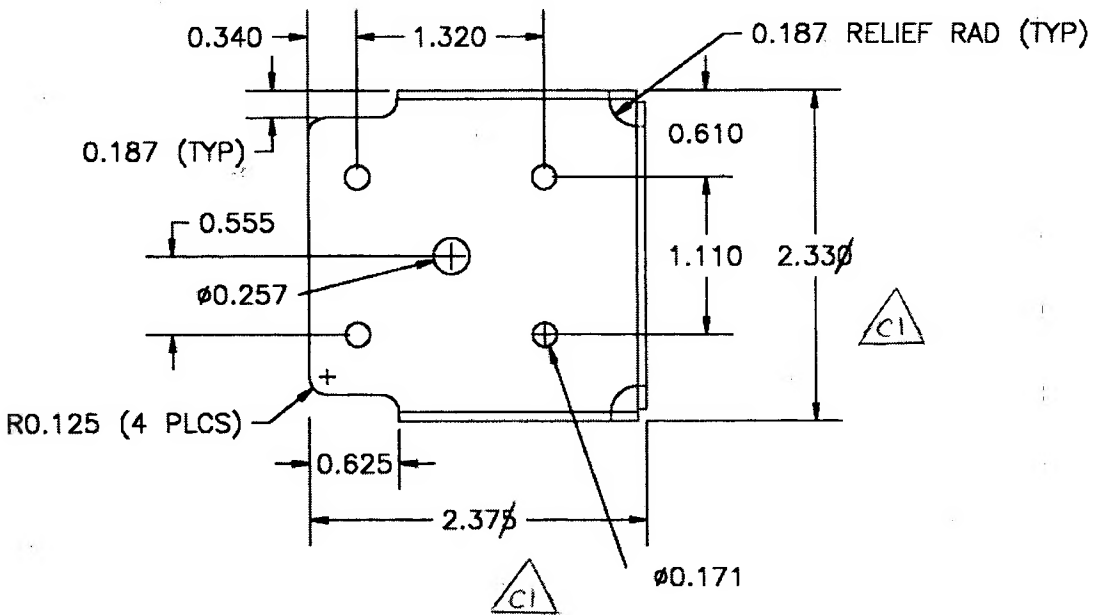
Measured by:	<i>MM</i>	Audited by:	<i>J</i>	Prototype Approval:	N/A
Date:	06/10/18	Date:	06/10/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.11.11	New Issue	KJ/JLM	<i>[Signature]</i>



RELEASED
06 06 20 13 03

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. C
J BRADLEY	K HAND		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 2
BW	FW	D2143	
DATE		TITLE	SCALE
92:07:10		HINGE BRACKET	
B	96:06:06	ADD FLAT PATTERN	
C	96:06:13	MATERIAL WAS 2024-13 .063 THICK	
CI	04.06.15	UPDATE DIMENSIONS	



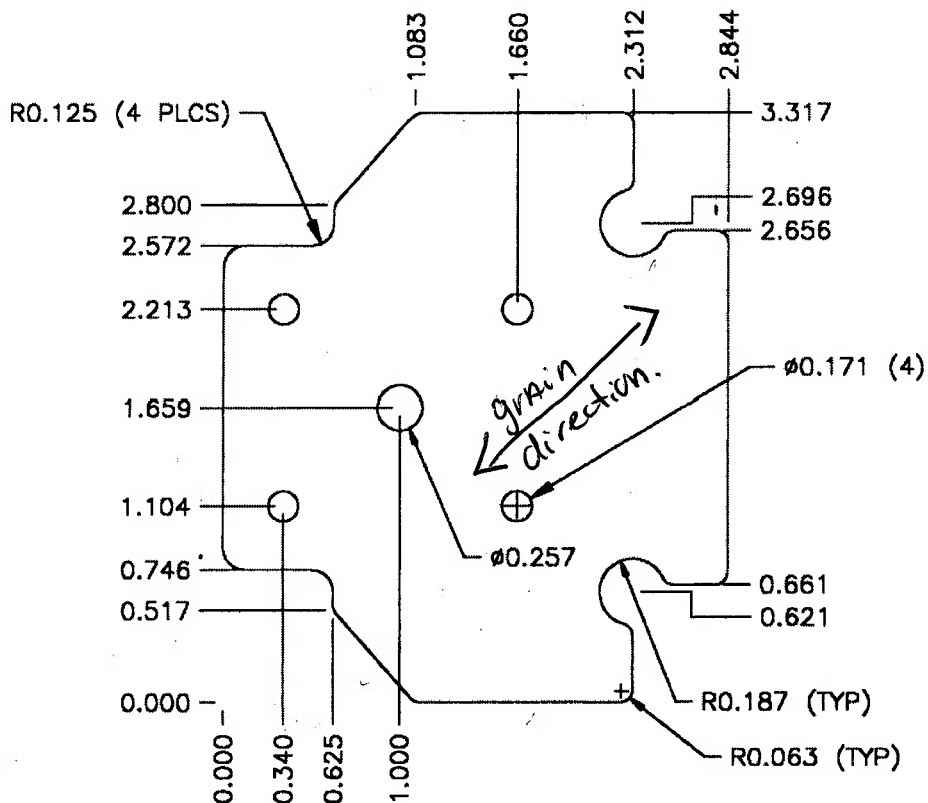
MATERIAL: 5052-H34, 0.040 THICK
FINISH: WHITE POWDER COAT HI-GLOSS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28948



DESIGN J BRADLEY	DRAWN BY K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2143	REV. c SHEET 2 OF 2
DATE 95:10:18	TITLE HINGE BRACKET FLAT PATTERN		SCALE 1:1

RELEASED
965620 BW



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38948
diagonal grain direction.

MATERIAL: 5052-H34, 0.040 THICK GRAIN ALONG 3.317